



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 195758



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV:C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	6/14/19		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		DAS
							Large Fab - 5		43
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	6/14/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	6/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24	DAS	
							QC 5 - 3	24	
							QC 5 - 43	9-89	
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	6/14/19	0.00 0.29	Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	BL 19-6-25
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)-B4B	1 pcs	6/14/19	0.00 0.93	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BL 19-6-26
					Powdercoat - 4 - B4B	
140	QC 3	1 pcs	6/14/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	ML 19-6-27
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	6/14/19	0.00 0.50	Handfinish - 4 - 1 - B4B	ML 19-6-28
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	

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				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160	QC 5	1 pcs	6/14/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
170	Packaging 3-1 - Stock - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - SA	1	6/14/19	0.00 0.00	QC 21 - SA - 21

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DAS
81
9-89

M 14-6-26

pcs

QC 21 - SA - 70

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QC 21 - SA - 53

70

9-19

Part Op 100 - Weld per dwg A/R S.S. rod Batch: 4138840 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

Master Unit # 010309

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5188852
D3913-1 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5172797
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5184576
D3913-3 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5178251
D3913-7 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5179688
D3913-9 ✓	Hinge Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5178219
D3916-041 ✓	Rib Assembly	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5183955
D3916-5 ✓	Light Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	1x5176451 2x5179611
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5121276
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5173533
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5180771
D4020-11 ✓	End Mesh, Basket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5186358
D4021-1 ✓	Handle Plate	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5179504
D4034-041 ✓	Aft Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5181423
D4034-043 ✓	Fwd Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5181719
D4672-1 ✓	Blanking Plate	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	1x5160008 1x5184347
M304EX0.75-16F ✓	Expanded Metal Flat SS	32 sf (32 ea) ✓	100-Large Fab - Basket - 1	5181090
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5179612-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	515567
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5157462
NAS1149F0332P	Washer	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5135478
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5170065
NAS1149FN832P	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136366

010601

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	2	0
	D3913-1	1	7	0
	D3913-15	1	29	0
	D3913-3	1	1	0
	D3913-7	2	20	0
	D3913-9	1	6	0
	D3916-041	2	5	0
	D3916-5	3	24	0
	D4016-1	3	15	0
	D4017-7	3	67	0
	D4017-9	2	22	0
	D4020-11	2	0	0
	D4021-1	3	15	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	21	0
	M304EX0.75-16F	32	322	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	273	0
	D2931	2	713	0
	D4021-5	2	14	0
	MS20600-AD4W3	2	354	0
	MS21042L3	6	2,144	0
	NAS1149F0332P	12	3,759	0
	NAS1149FN832P	2	1,732	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ _____ _____			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S192249



Part: D3913-041

Job No: 195758

Serial No/Batch: S192249

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/20/19